

154987

Wednesday, January 04, 2017 2:21:36 PM

N900040100

Setup Start *NS1*

Stop *NS2*

51

Cust Item ID:

Start Date: 1/17/2017 **Start Qty:** 51.00

Required Date: 1/23/2017 **Req'd Qty:** 51.00

Customer:

Run Start *NR1*

Approvals: Process Plan: 21 Date: 14 JAN 2017

Tooling: _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Draw Nbr	Revision Nbr
D3492	E

100	0.00
-----	------

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.17

Hardinge CNC Lathe Small

1-Turn as per Folio FA632 & Dwg D3492

Dwg Rev: 5

Folio Rev: AA

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.08

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.17

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Cust Item ID:

Required Date: 1/23/2017 **Req'd Qty:** 51.00 ***51***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

Chemical Conversion Coat per QSI005 4.1

0.00

130

Memo

0.00

Hand Finishing

BFB

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

n 136113.

0.00

Powdercoat

Memo

Powder Coating

(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30
RE: 320°
8:00

150

QC3- Inspect Part Finish

0.00

150

Memo

0.08

OC

Quality Control

DAS
38
9-89

JAN 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/17/2017 **Start Qty:** 51.00 ***51***

Cust Item ID:

Required Date: 1/23/2017 **Req'd Qty:** 51.00 ***51***

Customer:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Identify as per dwg & Stock Location: HP-661

0.00

160

0.08

Packaging

Memo

LOCATION : FP001

Packaging

QC21- Final Inspection - Work Order Release

0.00

170

0.85

QC

Memo

Quality Control

DAS
21

9-89

JAN 26 2017

JAN 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, January 04, 2017 2:21:40 PM

Page 1

Work Order ID: 154987

154987

Parent Item: D3492-3

D3492-3

Parent Item Name: Plug

Start Date: 1/17/2017

Required Date: 1/23/2017

Start Qty: 51.00

Required Qty: 51.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	55.6990	0.06	3.221053			

M6061T6R0 750

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

55.699

m135377

0.6

m135612

0.745

m135861

6.354

m136327

24

m136463

24

3.50

DAS
45 17-01-07
2.89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

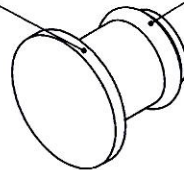
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OTHER :																																																																							

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 154987/MWS
17-01-04

D3492-XXX PLUG PARTS LIST

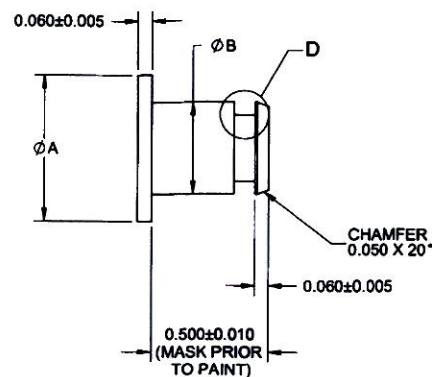
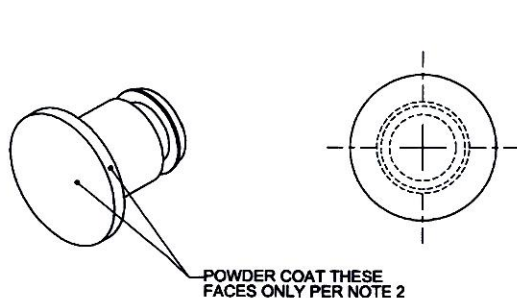
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
				1			1	NAS1611-015	O-RING
					1			NAS1611-016	O-RING

NOTES:

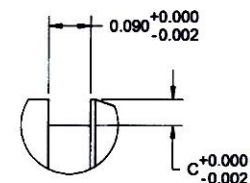
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2013-11-13

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053. CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	14	D3492	SHEET 1 OF 2
APPROVED	14	TITLE	SCALE
DE APPR.	14	PLUG	NTS
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

△

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. E
MFG. APPR.	AS	D3492	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	PLUG	4:1
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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